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D2581

Job Sheet 212497



Part No: D2581

Job Qty: 14 pcs

Part Name: Mounting Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/25/20

Job Tracking No:

Due Date: 9/11/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP D 01.07.17 Added info to step 2 SM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	9/10/20	0.17	0.49	Waterjet - Flow		020/08/31	
						Waterjet - Omax			
120	QC 8	10 pcs	9/10/20	0.00	0.00	QC 8 - 12			
						QC 8 - 14			
						QC 8 - 17			
						QC 8 - 20			
						QC 8 - 25			
						QC 8 - 3			
						QC 8 - 32			
						QC 8 - 33			
						QC 8 - 35			
						QC 8 - 39			
						QC 8 - 4			
						QC 8 - 44			
						QC 8 - 45			
						QC 8 - 49			
						QC 8 - 58			
						QC 8 - 8			
						QC 8 - 9			
						QC 8 - 68			
						QC 8 - 67			
						QC 8 - 1 (A)			
						QC 8 - 47			
						QC 8 - 40			
						QC 8 - 52			
						QC 8 - 23			
						QC 8 - 57			
						QC 8 - 76			
						QC 8 - 61			
						QC 8 - 66			
						QC 8 - 73			

DAS

40

9-89

SEP 01 2020

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				QC 8 - 82	
130 Small Fab - 2 - B4B	10 pcs	9/11/20	0.00 0.08	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	SEP 03 2020
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 QC 5	10 pcs	9/11/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	SEP 03 2020 DAS 40
				QC 5 - 61	9-89
				QC 5 - 81	
				QC 5 - 82	
150 Packaging 3-1 - Stock - B4B	10 pcs	9/11/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	SEP 03 2020 DAS 80
				Packaging 3 - 4 - B4B	WA004-6 9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
160 QC 21 - SA	10 pcs	9/11/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		SEP 04 2020 DAS
				QC 21 - SA - 9		70
				QC 21 - SA - 77		9-89

Part Op **100** - 1-Cut as per Dwg D2581 Dwg Rev: AI Prog Rev: AI 2-Deburr if necessary
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (small fab)Form as per dwg
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Identify as per dwg & Stock Location: _____)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.1870 sf (.0187 ea)	100-Waterjet - Flow - 1	S243465

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	0	97	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Bracket	0.328inches + 0.006 - 0.001	0.334 0.327		
2	Mounting Bracket	0.191inches + 0.005 - 0.001	0.196 0.190		
3	Mounting Bracket	0.750inches ± 0.010	0.760 0.740		
4	Mounting Bracket	3.596inches ± 0.010	3.606 3.586		
5	Mounting Bracket	2.846inches ± 0.010	2.856 2.836		
6	Mounting Bracket	1.995inches ± 0.010	2.005 1.985		
7	Mounting Bracket	0.250inches ± 0.010	0.260 0.240		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S297542



Part: D2581

Job No: 212497

Serial No/Batch: S297542

Revision: REV.A1

Inspector:

Exp Date:

Instructions: Various STC's

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